

Work Order ID 113568

April-08-14 10:45:39 AM

\*113568\*

Page 1

Item ID: D3589-11

Revision ID:

Item Name: Fwd Guide Plate

Start Date: 2/27/14

Start Qty: 6.00

Required Date: 2/27/14

Req'd Qty: 6.00

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3589

C

100

0.00

\*100\*

Waterjet

FLOW CNC Waterjet

304 . 063"

Memo

Cut as per dwg D3589

Prog Rev: \_\_\_\_\_

Dwg Rev: \_\_\_\_\_

Deburr as required

0.00

6 mm 14/04/10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

6 mm 14/04/10

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Item ID: D3589-11 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Fwd Guide Plate  
 Start Date: 2/27/14 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 2/27/14 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID         | Operation<br>Description                                       | Set Up/<br>Run Hours    | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp                   |
|--|--|-------------------------|---------|--------|--------------|---------------|---------------|------------------|----------------------------------|
| 120<br>*120*<br>QC<br>Quality Control  | QC8- Inspect parts - second check<br><br>Memo                  | 0.00<br>0.00<br>14/4/16 |         |        |              | 6             |               |                  |                                  |
| 130<br>*130*<br>Packaging<br>Packaging | Identify as per dwg & Stock Location: <u>WAC02</u><br><br>Memo | 0.00<br>0.00            |         |        |              | 6x            |               |                  | DAS<br>28<br>9-89<br>APR 10 2014 |
| 140<br>*140*<br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo        | 0.00<br>0.00            |         |        |              |               |               |                  | PL 14-04-14<br><br>14-04-11      |

# Picklist Print

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Work Order ID: 113568

\*113568\*

Parent Item: D3589-11

\*D3589-11\*

Parent Item Name: Fwd Guide Plate

Start Date: 2/27/14

Required Date: 2/27/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-06-05 new issue DD verified by:ec IPP Rev:B 09-02-20 rev.b asper dwg DD verified by:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S16GA

Purchased

No

100

sf

196.7670

0.04

0.252632

**\*M304S16GA\***

304/316 Sheet .063

\*\*

0.4 mm/14/04/10

Location

Loc Qty

Loc Code

MAT020

196.767

M126915

1.487

M127821

122.53

M128054

33.89

M128423

38.86

0.4

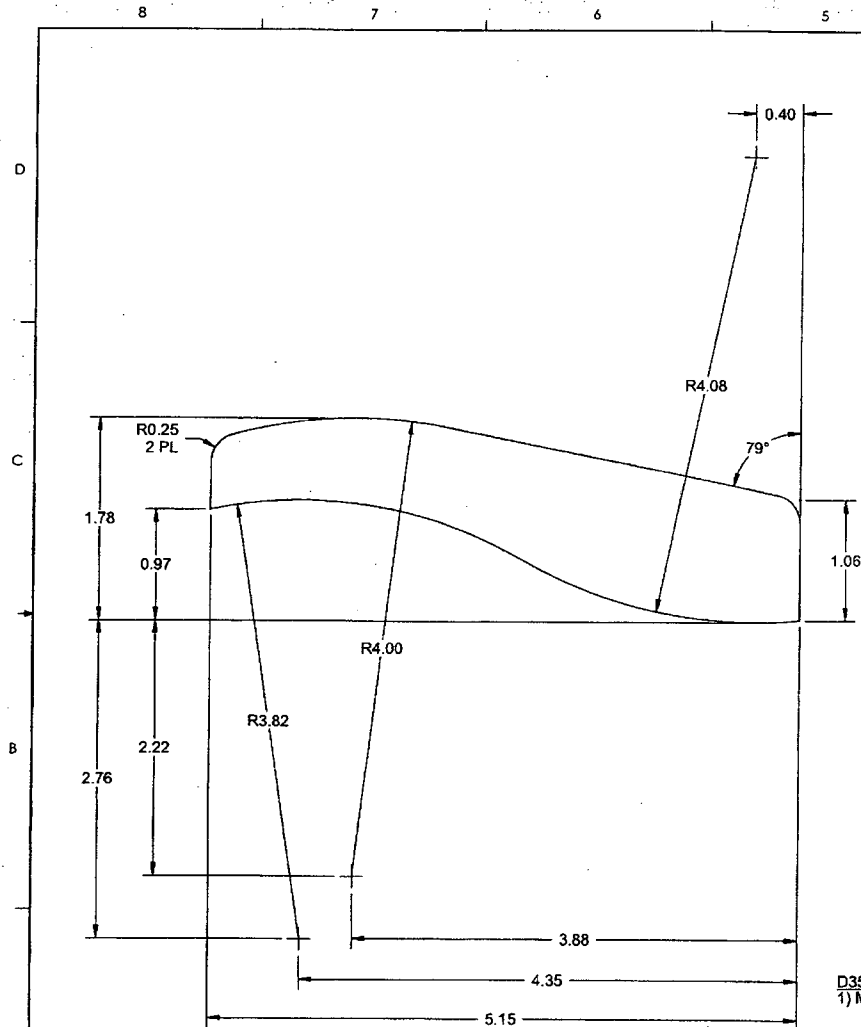


113568 ✓

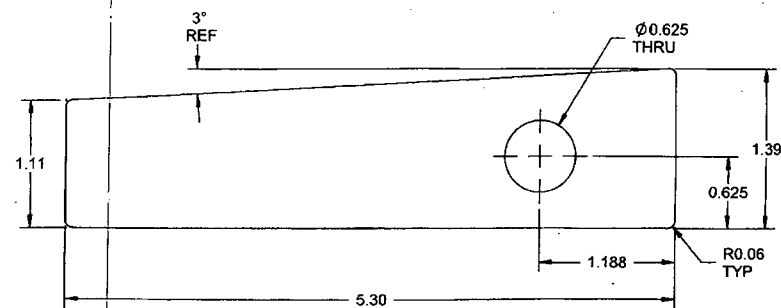
## FIRST ARTICLE INSPECTION CHECKLIST

AS27

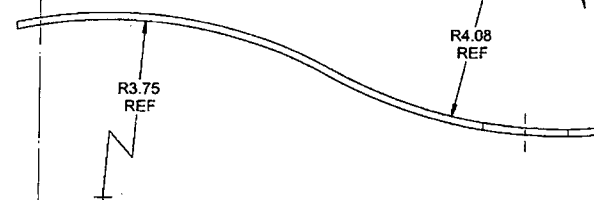
9-89



**D3589-9 FORWARD GUIDE PLATE**



**D3589-11F FORWARD GUIDE PLATE  
FLAT PATTERN**



**D3589-11 FORWARD GUIDE PLATE  
(MAKE FROM D3589-11F)**

**D3589-9/-11/-11F NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET,  
PER AMS 5513 OR AMS 5524,  
OR MIL-S-6059 (ANNEALED) 2B FINISH  
16 GAUGE (0.063 THICK),  
(REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs EACH
- 8) CONTROL SHAPE PER DT9021 TEMPLATE

|            |          |   |   |              |
|------------|----------|---|---|--------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b><br>HAWKESSBURY, ONTARIO, CANADA |   |              |
| DRAWN      |          |   | REV. C  |              |
| CHECKED    |          |   | DRAWING NO. <b>D3589</b>  | SHEET 6 OF 8 |
| MFG. APPR. |          |   | TITLE   | SCALE        |
| APPROVED   |          |   | <b>LATCH ASSEMBLY</b>   | NTS          |
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2012-07-16